



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4884-1

Job Sheet 192142



Part No: D4884-1

Job Qty: 4 pcs

Part Name: End Fitting, Eye



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/18/19

Job Tracking No:

Due Date: 4/12/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A SHEET 1 IPP REV:A NEW ISSUE 14-01-13 JLM VERIFIED BY:DD IPP REV:B DOING PART IN
HOUSE FROM NOW ON. RQ 16.11.02 VERIFIED BY: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
105	Doosan - 1	4 pcs	4/12/19	4/12/19	0.00	3.01	Doosan - 1	
110	QC 2	4 pcs	4/12/19	4/12/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 54	
							QC 2 - 56	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S176902



Part: D4884-1

Job No: 192142

Serial No/Batch: S176902

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 05/01/19

Plex 3/18/19 11:01 AM Dart.lajeunesse.marie

					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
115	HAAS 5 Axis - B4B	4 pcs	4/12/19	0.00 3.70	HAAS - 5 - B4B	
117	QC 2	4 pcs	4/12/19	0.00 0.00	QC 2 - 1	
					QC 2 - 12	
					QC 2 - 14	
					QC 2 - 17	
					QC 2 - 19	
					QC 2 - 2	
					QC 2 - 20	
					QC 2 - 22	
					QC 2 - 23	
					QC 2 - 25	
					QC 2 - 32	
					QC 2 - 33	
					QC 2 - 35	
					QC 2 - 39	
					QC 2 - 4	
					QC 2 - 40	
					QC 2 - 44	
					QC 2 - 45	
					QC 2 - 48	
					QC 2 - 49	
					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 54	
					QC 2 - 56	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
120	QC 8	4 pcs	4/12/19	0.00 0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
130	Outsource - 2 - NDT per	4 pcs	4/12/19		SKY002-VC	6

B.e 19-05-06

2019-05-06 KLY

QSI038					
140	Packaging 2-1 - Receive - B4B	4 pcs	4/12/19	0.00 0.00	Packaging 2 - 1 - B4B
					Packaging 2 - 2 - B4B
					Packaging 2 - 3 - B4B
					Packaging 2 - 5 - B4B
					Packaging 2 - 4 - B4B
					Packaging 2 - 6 - B4B
					Packaging 2 - 7 - B4B
					Packaging 2 - 8 - B4B
					Packaging 2 - 9 - B4B
					Packaging 2 - 10 - B4B
					Packaging 2 - 11 - B4B
					Packaging 2 - 12 - B4B
					Packaging 2 - 13 - B4B
					Packaging 2 - 14 - B4B
					Packaging 2 - 15 - B4B
					Packaging 2 - 16 - B4B
					Packaging 2 - 17 - B4B
					Packaging 2 - 18 - B4B
					Packaging 2 - 19 - B4B
					Packaging 2 - 20 - B4B
					Packaging 2 - 21 - B4B
					Packaging 2 - 22 - B4B
					Packaging 2 - 23 - B4B
					Packaging 2 - 24 - B4B
					Packaging 2 - 25 - B4B
					Packaging 2 - 26 - B4B
					Packaging 2 - 27 - B4B
					Packaging 2 - 28 - B4B
					Packaging 2 - 29 - B4B
					Packaging 2 - 30 - B4B
					Packaging 2 - 31 - B4B
					Packaging 2 - 32 - B4B
					Packaging 2 - 33 - B4B
					Packaging 2 - 34 - B4B
					Packaging 2 - 35 - B4B
					Packaging 2 - 36 - B4B
150	QC 5	4 pcs	4/12/19	0.00 0.00	QC 5 - 10
					QC 5 - 12
					QC 5 - 17
					QC 5 - 18
					QC 5 - 19
					QC 5 - 22
					QC 5 - 24
					QC 5 - 3
					QC 5 - 42
					QC 5 - 43
					QC 5 - 49
					QC 5 - 51
					QC 5 - 58
					QC 5 - 68
					QC 5 - 9
					QC 5 - 50
QC 5 - 30					
QC 5 - 40					
160	Packaging 3-1 - Stock - B4B	4 pcs	4/12/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B

6 pcs

OP MAY 08 2019

5x12x8 MAY 08 2019

DAS 40 9-89 MAY 08 2019

Plex 3/18/19 11:01 AM Dart.lajeunesse.marie

OP MAY 08 2019

5x12.4 SR MAY 08 2019

DAS
MAY 08 2019 40
9-89

					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
170 QC 21 - SA	4 pcs	4/12/19	0.00 0.00		QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	

Part Op 105 - (Doosan Lathe)-Machine blank as per Machinist's turning detail, folio+drawing D4884-1. 9-33

Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)

115 - (HAAS CNC vertical machine #5) Mill as per folio FB509.

117 - (QC2- Inspect parts off machine FAI/FAIB)

120 - (QC8- Inspect parts - second check)

130 - (Outsource process - NDT per QSI038 4.1)ISSUE P/O : _____

140 - (Outsource process - NDT per QSI038 4.1)

150 - (QC5- Inspect part completeness to step on W/O)

160 - (Identify as per dwg & Stock Location: _____) IDENTIFY AS PER QSI 044 6.1

170 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-H900-R1.500	17-4 SS H900 Round Bar 1.500"	1.4000 ft (.35 ea)	105-Doosan - 1	M 129 892

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
105-Doosan - 1	M17-4-H900-R1.500	1	70	0

Part Specifications

Specifications could not be found.

DART AEROSPACE LTD		Work Order: 192142
Description: End Fitting, Eye		Part Number: D4884-1
Inspection Dwg: D4884	Rev: A	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.500	+0.006/-0.001	.500	✓		Vern 1 Pro	
1.17	+/-0.030	1.162			↓	
R0.63	+/-0.030	.625			↓	
0.500	+/-0.005	.500			H-gauge	
0.030	+/-0.010	.03			Vern 1 Pro	
0.017	+/-0.010	.012			↓	
Ø0.670	+0.000/-0.001	.6685			↓	
30°	+/-0.5°	30°			↓	
Ø0.125	+0.004/-0.001	.126			↓	
30°	+/-0.5°	30°			↓	
Ø0.125	+0.004/-0.001	.126				
Ø1.14	+/-0.030	1.140	✓		↓	
1.132	+/-0.010	1.133	✓		SL10	Vern
Ø0.750	+0.000/-0.001	.7495	✓		SL02	Mic
0.66	+/-0.030	.658	✓		SL10	Vern
2.060	+/-0.005	2.062	✓		Height gauge	
R0.25	+/-0.030	.250	✓		Rad gauge	
1.81	+/-0.030	1.808	✓		SL10	Vern
3.65	+/-0.030	3.655	✓			
0.06 x 45°	+/-0.030 x +/-0.5°	.060	✓			
0.947	+/-0.010	.948	✓			
0.059	+/-0.010	.059	✓			
0.063	+/-0.010	.060	✓			
R0.06	+/-0.030	.062	✓		Rad gauge	
0.200	+/-0.010	.196	✓			
R0.25	+/-0.030	.250	✓		Rad gauge	
1.39	+/-0.030	1.393	✓		↓	

Measured by: P/SJ	Checked by: B.P.	QC Inspector:
Date: 19-04-30	Date: 19-05-06	Date:

Engineering Approval: (if necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	17.01.31	New Issue	KJ	MA

Entered: _____ Date: _____

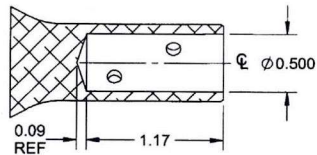


WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

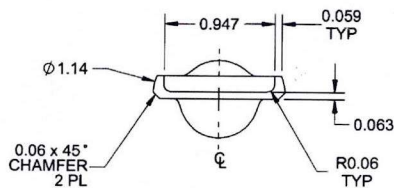
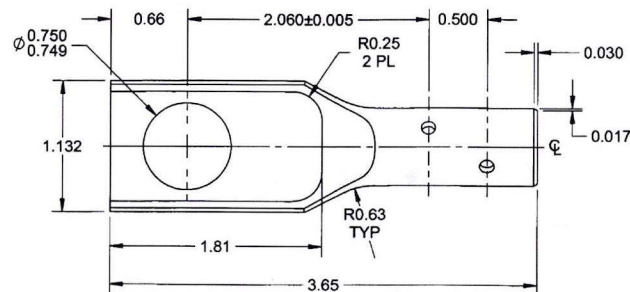
NCR No. _____

Route update only ☐

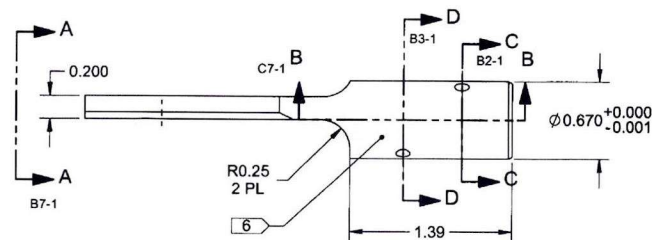
Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



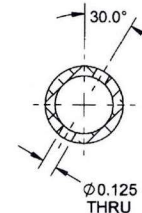
SECTION B-B C5-1



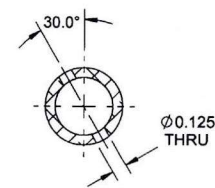
VIEW A-A B6-1



D4884-1 END FITTING, EYE



SECTION C-C C4-1



SECTION D-D C5-1

NOTES:

- 1) MATERIAL: 17-4 PH/S17400/TYP 630 SS ROUND BAR, H900 CONDITION
PER AMS 5643/ASTM A564
DART SPEC M17-4-R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.13 lbs
- 8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

APPROVED

A		NEW ISSUE		RF		13.09.16	
REV.		DESCRIPTION				BY DATE	
DESIGN		RF		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN		RF					
CHECKED		DC		DRAWING NO.		REV. A	
MFG. APPR.		JLM		D4884		SHEET 1 OF 2	
APPROVED		HS		TITLE		SCALE	
DE APPR.		DS		END FITTING		NTS	
DATE		13.12.01		COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043386



Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

Attention: Jenne, Heather

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043386

PO Date: 5/6/19

Due Date: 5/10/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	192142	D4884-1	End Fitting, Eye : Various STC's (Outsource process - NDT per QSI038 4.1)ISSUE P/O	Firmed X6	-	5/10/19 MAY 08 2019	6 pcs	0 pcs	6 pcs	\$14.833/pcs DP	\$89.00
2	192636	D4885-3	End Fitting : Various STC's ISSUE P/O LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417	Firmed X6	-	5/10/19 MAY 08 2019	6 pcs	0 pcs	6 pcs	\$14.833/pcs DP	\$89.00
Grand Total:											\$178.00

DAS
40
9-89

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 5/7/19 1:52 PM Dart.Guerin.Kimberley

**skyservice****Work Order Traveler**

Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO40306	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: POHB043386
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT ON:

✓ 6 END FITTING EYE, P/N# D4884-1, J/S# 192142

✓ 6 END FITTING, P/N# D4885-3, J/S#192636

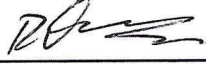
DAS
40
8-89**RECEIVED**

MAY 08 2019

DART AEROSPACE LTD.

Action Taken:					Date:	Initial/Stamp:
LIQUID PENETRANT INSPECTION CARRIED OUT IAW ASTM E-1417M-16 ***NO CRACK FOUND*** PEN, ZL-37 MPO#: 23206 CLEANER SKC-S MPO15030, EMU.(ZR-10B, MPO23451), DEV. MPO15030, UV LIGHT M-20142					MAY 07 2019	  KV
Description	Location	P/N	Qty	Batch	S/N Off	S/N On

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature: 	ACA/SCA Stamp 	Date:
Name: RICARDO VARGAS		MAY 07 2019